

Date: Monday, 4/28/2008 10:08:17 AM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT DOUBLER
Job Number : 38833	
Estimate Number : 13278	
P.O. Number :	Part Number : D37031
This Issue : 4/28/2008 S.O. No. :	Drawing Number : D3703 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PRELIM
Previous Run :	Material :
Written By : _____	Due Date : 5/5/2008 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A 08-04-24 new issue DD verified by:EC	

Additional Product

FOR ENGINEERING USE ONLY
~~PRELIMINARY ISSUE~~ ~~PROTOTYPE~~

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.5814 sf(s)/Unit Total : 0.5814 sf(s)
 6061T6 aluminium sheet .063" thick
 (M6061T6S063)
 Batch: 107387 HB 8-4-28

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3703
 Dwg Rev: PRE L HB 8-4-28
 Prog Rev: PRE L
 ****grain direction along 6.05*****
 2- Deburr if necessary HB 8-4-28

①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 090/04/28 (40)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Bend as per Dwg D3703

① 08-04-28 ②

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08-04-28

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SCRAP PART. NOT ADEQUATE FOR WSTALL.

08-05-22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Charge to
W/O # 00224A

MF 08-05-21

8 7 6 5 4 3 2 1

D

C

B

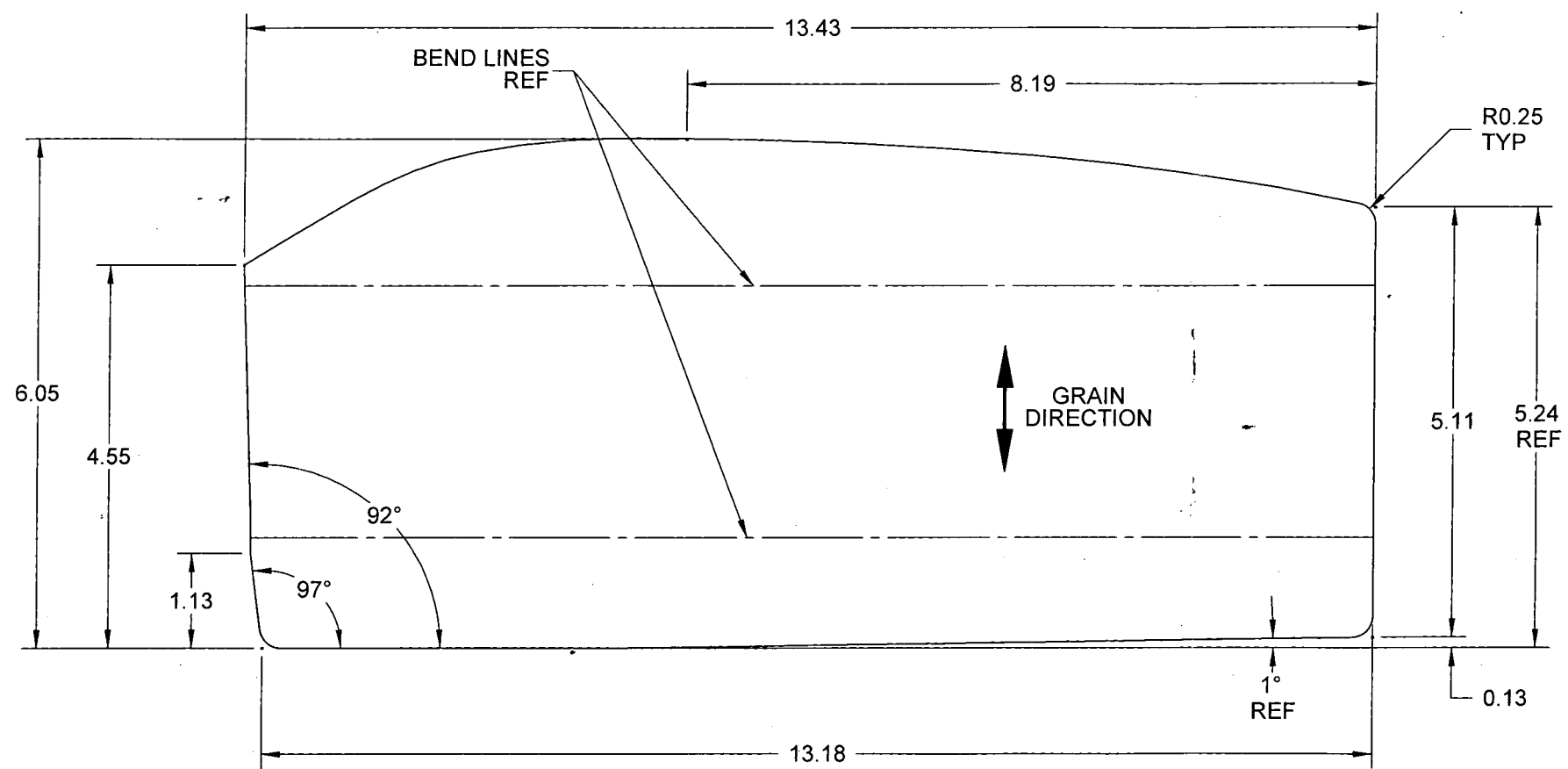
A

D

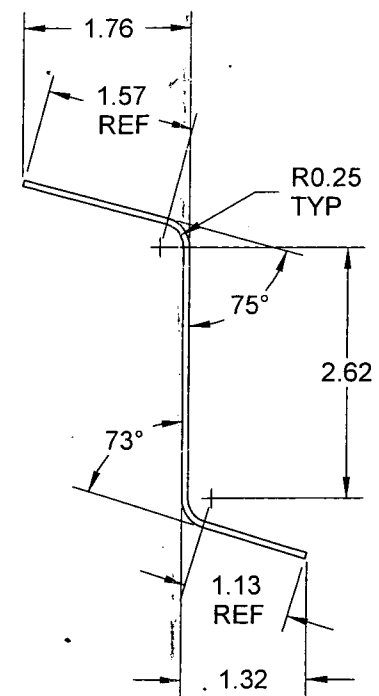
C

B

A



D3703-1F AFT DOUBLER FLAT PATTERN



**D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)**

PRELIMINARY ISSUE
08.04.24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
DATE	08.01.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761-041

Job #: 00224A

Date: 08.04.24

Product Name: FULL VERTICAL REF DOOR

Requested By: MB

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3700-1	INBOARD DOUBLER	08.02.29	Y	08.05.01	FOR TESTING	
1	D3700- 1 -3	OUTBOARD DOUBLER	08.02.29	Y	08.05.01	FOR TESTING	
1	D3703-1	AFT DOUBLER	08.01.30	Y	08.05.01	FOR TESTING	
1	D3703-3	AFT CORNER DOUBLER	08.01.30	Y	08.05.01	FOR TESTING	
1	D370 3 -5	AFT CAP	08.01.30	Y	08.05.01	FOR TESTING	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MAGNA STAINLESS DIV. DE CSM INC
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-

VENDU À /
SOLD TO:

LIVRÉ À /
SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO

K6A 1K7

COMMANDE SALES ORDER		CODE DE CLIENT CUSTOMER CODE		BON D'ACRAT DU CUSTOMER PURCHASER	
0165970		DART		5851	
LIVRÉ VIA SHIP VIA		CONDITIONS TERMS		DATE COMMANDE DATE ORDER	
NIR:R-557065-1		NET 30		Mar-	
CONTRÔLE DE QUALITÉ DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQUIRED <input type="checkbox"/>					
QUALITÉ - QUALITY		UNITÉ UNIT	N° DE COULÉE HEAT NUMBER	DESCRIPTION	
COMMANDES ORDRE	A VENIR - S/O				
40 8		1bs	F 1503CR	304L ROUND 1/4" DI	
26 26		1bs	41043	6061-T6 ALUM 3/4 S USE MTR #CA533	
30 131		1bs	1628331	6061-T6 .063 X 48 USE MTR #BZ853	
50 443		1bs	42603	6061-T6 AL FLAT 1 USE MTR #CE459	
TOTAL:					

NOMBRE DE PAQ.
NUMBER OF BOL'S

MTR-AVEC COMMANDE
MTR'S-WITH ORDER ☒

POSTE
MAIL ☐

TÉLÉCOPIEUR
FAX ☐

Age: 1

08:50:24

20080311

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END ☐

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Production/Admin:
Date
Received/Costing
Initial

Location

Initials of receiver (if shipment OK) Level 12

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M204T8040		128	0	0	128	
M601T63100X015		20	0	0	20	

Discrepancies

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A
Waybill Attached: Yes ☐ No ☒ N/A
Shipment Complete: Yes ☐ No ☒ N/A
QC6 Inspection ☐ N/A
Work Order ☐ N/A

Date: 8/3/12
Supplier: MACV4

Batch No: M1.7367
Part P/O: 5881

Receiving Report

BZ 853

DOC : V/0080236963

DATE : 2007-05-30

PROD. REF. : 0000217536/004

NRBST : 03484/04

PAGE : 1/ 2

INSPECTION CERTIFICATE

Aleris
Europe

CUSTOMER : ALERIS ALUMINUM US SALES INC.

Aleris Aluminum Duffel BVBA
A. Stocklaan 67, 2570 Duffel - Belgium

YOUR ORDER NUMBER : P08858 (CHARLESTON PO#5001-E)
OUR ORDER NUMBER : 03484/04
DOCUMENT NUMBER : V/0080236963

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 AMS 4027M ASTM B209-04
DIMENSIONS : 144" X 48" X .063"
ARTICLE NO. :

08/3/12

COIL NUMBER	CST NUMBER	CHEMICAL COMPOSITION (%)							
		MIN	SI	FE	CU	MN	MG	CR	TI
		MAX	0,40		0,15		0,8	0,04	
			0,8	0,7	0,40	0,15	1,2	0,35	0,15
004	1628301		0,62	0,4	0,19	0,07	1,0	0,15	0,03
005	1628331		0,68	0,4	0,20	0,08	1,0	0,17	0,03
OTHERS : EACH					MIN		0,05 MAX		
TOTAL					MIN		0,15 MAX		

MECHANICAL PROPERTIES				
TEST- NUMBER	(T) = TRANSVERSAL		(L) = LONGITUDINAL	
	1 N/MM2 = 1 MPA = 0,1 HBAR		0,102 KG/MM2 = 0,145 KSI	
	/A = REAR END	/M = MIDDLE	/F = FRONT END	/O = RANDOM SAMPLING
	RM	RP02	A	
	KSI	KSI	%	
	42	35	10	
004	/A	50	42	13
004	/M	49	42	16
004	/F	50	41	13
005	/A	50	41	16
005	/M	50	41	13
005	/F	50	41	18

Aleris Aluminum Duffel BVBA

59483
24/3/12

DOC : V/0080236963

DATE : 2007-05-30

PROD. REF. : 0000217536/004

NRBST : 03484/04

PAGE : 2/ 2

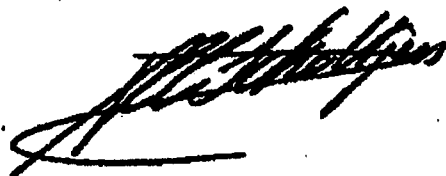
Aleris

Europe

Aleris Aluminum Duffel BVBA
A. Stockman 67, 2570 Duffel - Belgium

DATE	SOLUTION	HEAT TREATMENT	COIL NUMBER
	004	STENCILLING	: WEEK 17 / YEAR 2007
	005	STENCILLING	: WEEK 17 / YEAR 2007

HEAD OF LABORATORY,
XAVIER SCHELTJENS



Aleris Aluminum Duffel BVBA